Work Orde Thursday, Octobe	r ID 62945 er 14, 2010 12:33:39 PM					K		<u> </u>		Page 1
Revision ID:	D3535-39 Wearshoe		Accept				Setup	Start Stop		
Start Date: Required Date: Reference:	10/14/2010 Start Qty: 12.0 10/22/2010 Req'd Qty: 12.0			Cust Item II Customer:	D:					
	Process Plan:QC:	Date: 10-10-14	Tooling:		te:		Run	Start Stop		
Sequence ID/ Work Center ID	Operation Description	· ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Acc Code Qty			Reject Number	Insp. Stamp
Draw Nbr D3535	Revision Nbr Rev B							,		
Waterjet FLOW CNC Waterjet		per Dwg D3535 □Dwg Rev:	0.00 0.00 <b>§</b> □Prog Rev:_ <b>§</b>	<b>}</b> □2-			<u>310-10</u>	٦٩	(1)	)
110  QC  Quality Control	QC2- Inspect parts of  Memo	f machine FAI/FAIB	0.00			(	<u>B [0~10</u>	)- I9		
	QC8- Inspect parts - s	second check	0.00			; U				April 19
QC Quality Control	Memo	A1272	0.00							7,000

W/O:			W	<b>VORK ORDER CHANGE</b>	S				4
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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#### Work Order ID 62945

Thursday, October 14, 2010 12:33:40 PM



Page 2

Item ID:

D3535-39

Accept



Setup Start

Run



**Revision ID:** Item Name:

Wearshoe

**Start Date:** 10/14/2010 **Required Date: 10/22/2010** 

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

**Approvals:** 

Process Plan:

Date: Date:

Tooling: SPC (Y/N): Date:

Date:

Code

Tool # Plan

Stop

Reject

Qty

Start

Stop

Insp.

Stamp

Reject

Number

Sequence ID/

**Work Center ID** 

130

Brake NC

Brake NC

Operation **Description** 

NC BRAKE

Set Up/ **Run Hours** 

0.00

0.00

Memo

Deburr if necessary □ Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. □Identify as D3535-41 □ Form Joggle on brake using Jig DT8158 as per

Dwg D3535

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Accept

Qty

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00 pl 10-10-22

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W/O:			WC	RK ORDER CHANGES		··		*
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DATE	STEP	Description of NC		Corrective Action Section B		Verificati	ion Approval	Approval
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#### Work Order ID 62945

Thursday, October 14, 2010 12:33:40 PM



Page 3

Item ID:

D3535-39

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Wearshoe

QC:

**Start Date:** 

10/14/2010 **Required Date: 10/22/2010**  **Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID: Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

**Tooling:** SPC (Y/N): Date:

Date:

Tool # Plan

Code

Start Run

Reject

Number

Stop

Reject

Qty

Insp.

Stamp

Sequence ID/ Work Center ID

160

Quality Control

Operation **Description** 

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

0.00

=> Il 10/0/27

170

Packaging

Packaging

Memo

Identify as per dwg & Stock Location 10-18 0.00 PH 10-10-32

0.00

Accept

Qty

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/22 /5/-MF 10-10-22

W/O:			V	VORK ORDER CHANG	ES				<u>, , , , , , , , , , , , , , , , , , , </u>	1
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#### **Picklist Print**

Thursday, October 14, 2010 12:33:49 PM

Work Order ID: 62945

D3535-39 Parent Item:

Parent Item Name: Wearshoe



**Start Date:** 10/14/2010

Required Date: 10/22/2010

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	108.6987	0.951	12.01263			
											B10-19	2-19	

304/316 .040 Sheet

Location	Loc Oty	Loc Code	
MAT	85.9522		
114574	10.6522		
115762	75.3		115762
MAT20	22.7465		
112885	2.7475		
113062	0.699		
115440	19.3		



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DART AEROSPACE LTD	Work Order:	42945
Description: Wearshoe	Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X	F	irst Article	F	Proto	type	)
		A - 41				

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815.	4		T 1361	
32.775	+/-0.010		A		٢	
29.275	+/-0.010	29.275	<b>X</b>		7	
25.775	+/-0.010	25.775	A		7	
23.250	+/-0.010	23.256	*		7	
19.750	+/-0.010	19.750	R		7	
17.750	+/-0.010	17.756	8		7	
14.250	+/-0.010	14.250	14		T	
9.500	+/-0.010	9.500	$\forall$	<u></u>	T	
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28.00	+/-0.030	∂8.∞)	\$		7	
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0.300	+/-0.010	307	X.		V	
0.300	+/-0.010	.306	0		V	<u> </u>
0.038	+/-0.010	,036	2		V	
			1			

Measured by:	Audited by:		Prototype Approval:	N/A
Date: 10-10-19	Date:	1610-19	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	07.07.18	New Issue	KJ/JLM of B

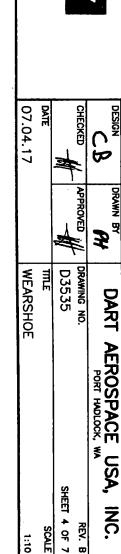
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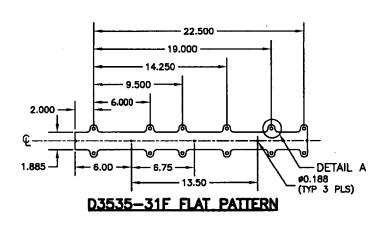
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wlo 62945

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RELEASE

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21.000
9.500
1.885 DETAIL A  #0.188 (TYP 3 PLS)
D3535-33F FLAT PATTERN

D3535-33 BEND DETAIL

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION





PURPOSE

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AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524. 1) MATERIAL: 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

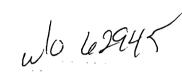
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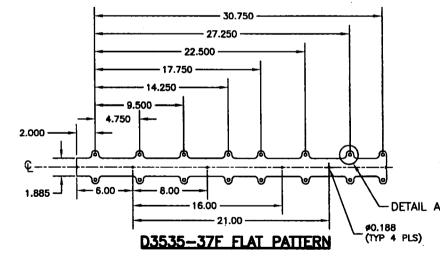
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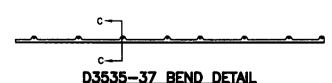
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D3535-35 BEND DETAIL

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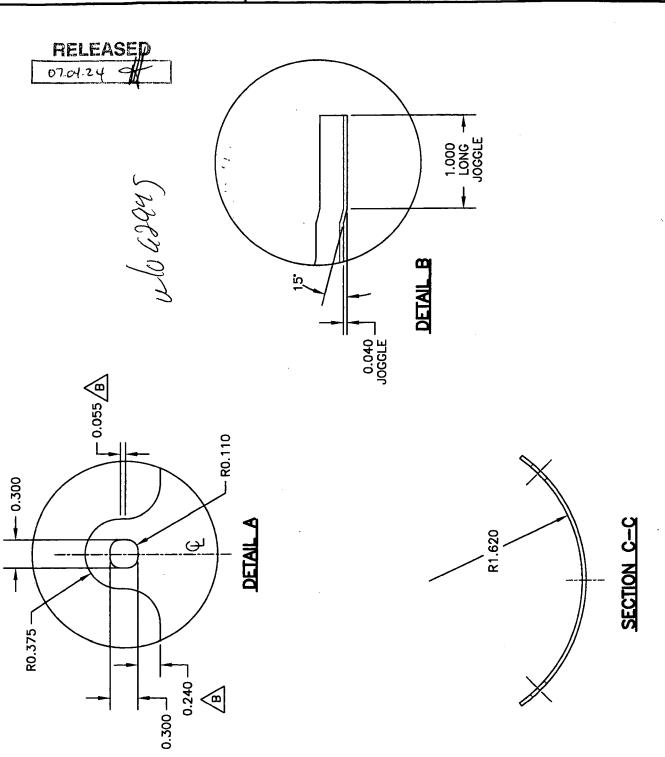
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